

## ABSTRACT

A unitary lid for the casing of an electrochemical energy storage device is described. The lid has a terminal lead ferrule and a fill port formed from a single blank in a machining process. The lid does not require any welding except for securing it to the open end of a casing container. The ferrule supports a terminal lead insulated therefrom by glass. A thermoplastic insulator material encases the ferrule and a portion of the terminal lead extending below the lid. In that manner, the insulator helps prevent contact between the anode and the cathode in the vicinity of the lid.